DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-007832
Date Inspected: 17-Jul-2009

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 1300
OSM Departure Time: 2130
Location: Muroran, Japan

CWI Name: Pin-Tang Hsu

Inspected CWI report:	☐	Yes	☑	No	☐	N/A
Electrode to specification:	☑	Yes	☐	No	☐	N/A
Qualified Welders:	☑	Yes	☐	No	☐	N/A
Approved Drawings:	☑	Yes	☐	No	☐	N/A

CWI Present:	☑	Yes	☐	No		
Rod Oven in Use:	☑	Yes	☐	No	☐	N/A
Weld Procedures Followed:	☑	Yes	☐	No	☐	N/A
Verified Joint Fit-up:	☑	Yes	☐	No	☐	N/A
Approved WPS:	☑	Yes	☐	No	☐	N/A
Delayed / Cancelled:	☐	Yes	☑	No	☐	N/A

Bridge No: 34-0006
Component: Tower, Jacking and Deviation Saddles

Summary of Items Observed:

On this date, 7/17/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W2 - The following welders were observed by this QA Inspector in Fabrication Shop #4 FCAW welding per WPS SJ-3011-5 using TM95 consumable weld wire on one weld joint identified as W2S-2U, cast stem to plate stem, they were S.Watanabe 08-5790, M.Matudate 08-5151, T.Watanabe 08-5153. The procedure parameters were monitored by QC CWI Mr. Chung Fu Kuan on a random basis. Following shift change the welders, as observed by the QAI were R.Iizuka 06-2643 as well as T.Kawakami 08-5079 and their parameters were scrutinized by CWI Mr. Pin-Tang Hsu.

W2W3 - Built up plate portion has been mounted atop the Cast section (inverted). An observation was made by this QA Inspector regarding a condition that has been noted on previous saddle sections in previous reports. The plate #'s, while having the correct thicknesses, are not per plan. The QA Inspector immediately informed Mr. Hideaki Kon of the condition via phone con, Mr. Kon and Mr. Sato proceeded to Fabrication shop where it was again agreed that the condition exists and documents will be drafted to follow the piece mark.

TOWER SADDLES

T1-2 - Saddle section has been Post Weld Heat Treated and currently sits outside the oven in Fabrication Shop #4.

T1-3 - Base plate, 9-4, was welded by six individuals, first shift was T.Sudo 03-3082, M.Yamashita 73-4195 both welding joint 9Y-12L-2 and K.Sadakawa 06-2929 welding 9Y-12L-3, second shift welders were K.Nakasato 91-2247, M.Kubota 74-3666 and Y.Maeyama 94-5234 in process of joints 9Y-12L-1, 9Y-12L-2 and 9Y-12L-3 respectfully. Procedure in use was SJ-3012-3, FCAW, 1.6mm TM55 consumable weld wire, in Fabrication Shop #4. These functions were being monitored by QC CWI Mr. Pin-Tang Hsu on a random basis.

EAST SADDLES

E2E1 - Cast section is now undergoing repair welding to excavations and lack of thickness areas identified in ECS BG-ECS-08-038, by K.Komai 06-8002. Procedure and parameters met SJ-3026-4 for SMAW process and 5mm E9016 electrode in Foundry.

E2W1 - This Caltrans Mets/OSM QA Inspector witnessed the mechanical tensile and Charpy impact test performed in JSW Laboratory on test specimens for E2W1 East Saddle casting. The results have been assigned a Caltrans Lot# of B275-014-09.

West Jacking Saddle - Cast Section is being ground by hand held power grinders by three individuals to provide a proper surface to meet ASTM A802 and to provide a appropriate surface to NDE. The cast section is located in the Foundry, approximately 70% complete.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer